

This Page Is Inserted by IFW Operations  
and is not a part of the Official Record

## **BEST AVAILABLE IMAGES**

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images may include (but are not limited to):

- BLACK BORDERS
- TEXT CUT OFF AT TOP, BOTTOM OR SIDES
- FADED TEXT
- ILLEGIBLE TEXT
- SKEWED/SLANTED IMAGES
- COLORED PHOTOS
- BLACK OR VERY BLACK AND WHITE DARK PHOTOS
- GRAY SCALE DOCUMENTS

**IMAGES ARE BEST AVAILABLE COPY.**

**As rescanning documents *will not* correct images,  
please do not report the images to the  
Image Problem Mailbox.**

EV085432260

EV026159369

EL169866340

EL979978081

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

APPLICATION FOR LETTERS PATENT

\* \* \* \* \*

Integrated Circuitry, Methods Of Fabricating  
Integrated Circuitry, Methods Of Forming Local  
Interconnects, And Methods Of Forming Conductive  
Lines

\* \* \* \* \*

INVENTOR

H. Montgomery Manning

ATTORNEY'S DOCKET NO. MI22-1013

1 Integrated Circuitry, Methods Of Fabricating Integrated Circuitry,  
2 Methods Of Forming Local Interconnects, And Methods Of Forming  
3 Conductive Lines

4 TECHNICAL FIELD

5 This invention relates to integrated circuitry, to methods of  
6 fabricating integrated circuitry, to methods of forming local interconnects,  
7 and to methods of forming conductive lines.

8 BACKGROUND OF THE INVENTION

9 The reduction in memory cell and other circuit size implemented  
10 in high density dynamic random access memories (DRAMs) and other  
11 circuitry is a continuing goal in semiconductor fabrication. Implementing  
12 electric circuits involves connecting isolated devices through specific  
13 electric paths. When fabricating silicon and other semiconductive  
14 materials into integrated circuits, conductive devices built into  
15 semiconductive substrates need to be isolated from one another. Such  
16 isolation typically occurs in the form of either trench and refill field  
17 isolation regions or LOCOS grown field oxide.

18 Conductive lines, for example transistor gate lines, are formed  
19 over bulk semiconductor substrates. Some lines run globally over large  
20 areas of the semiconductor substrate. Others are much shorter and  
21 associated with very small portions of the integrated circuitry. This  
22 invention was principally motivated in making processing and structure  
23  
24

1 improvements involving local interconnects, although the invention is not  
2 so limited.

### 3 4 5 SUMMARY OF THE INVENTION

6 The invention includes integrated circuitry, methods of fabricating  
7 integrated circuitry, methods of forming local interconnects, and methods  
8 of forming conductive lines. In one implementation, a method of  
9 fabricating integrated circuitry comprises forming a conductive line having  
10 opposing sidewalls over a semiconductor substrate. An insulating layer  
11 is deposited over the substrate and the line. The insulating layer is  
12 etched proximate the line along at least a portion of at least one  
13 sidewall of the line. After the etching, an insulating spacer forming  
14 layer is deposited over the substrate and the line, and it is  
15 anisotropically etched to form an insulating sidewall spacer along said  
16 portion of the at least one sidewall.

17 In one implementation, a method of forming a local interconnect  
18 comprises forming at least two transistor gates over a semiconductor  
19 substrate. A local interconnect layer is deposited to overlie at least  
20 one of the transistor gates and interconnect at least one source/drain  
21 region of one of the gates with semiconductor substrate material  
22 proximate another of the transistor gates. In one aspect, a conductivity  
23 enhancing impurity is implanted into the local interconnect layer in at  
24 least two implanting steps, with one of the two implantings providing

1 a peak implant location which is deeper into the layer than the other.  
2 Conductivity enhancing impurity is diffused from the local interconnect  
3 layer into semiconductor substrate material therebeneath. In one aspect,  
4 a conductivity enhancing impurity is implanted through the local  
5 interconnect layer into semiconductor substrate material therebeneath.

6 In one implementation, field isolation material regions and active  
7 area regions are formed on a semiconductor substrate. A trench is  
8 etched into the field isolation material into a desired line configuration.  
9 A conductive material is deposited to at least partially fill the trench  
10 and form a conductive line therein.

11 In one implementation, integrated circuitry comprises a  
12 semiconductor substrate comprising field isolation material regions and  
13 active area regions. A conductive line is received within a trench  
14 formed within the field isolation material.

15 Other implementations are disclosed, contemplated and claimed in  
16 accordance with the invention.

## 17 18 19 BRIEF DESCRIPTION OF THE DRAWINGS

20 Preferred embodiments of the invention are described below with  
21 reference to the following accompanying drawings.

22 Fig. 1 is a diagrammatic sectional view of a semiconductor wafer  
23 fragment at one processing step in accordance with the invention.  
24

1        Fig. 2 is a view of the Fig. 1 wafer at a processing step  
2 subsequent to that shown by Fig. 1.

3        Fig. 3 is a view of the Fig. 1 wafer at a processing step  
4 subsequent to that shown by Fig. 2.

5        Fig. 4 is a view of the Fig. 1 wafer at a processing step  
6 subsequent to that shown by Fig. 3.

7        Fig. 5 is a view of the Fig. 1 wafer at a processing step  
8 subsequent to that shown by Fig. 4.

9        Fig. 6 is a view of the Fig. 1 wafer at a processing step  
10 subsequent to that shown by Fig. 5.

11       Fig. 7 is a view of the Fig. 1 wafer at a processing step  
12 subsequent to that shown by Fig. 6.

13       Fig. 8 is a view of the Fig. 1 wafer at a processing step  
14 subsequent to that shown by Fig. 7.

15       Fig. 9 is a view of the Fig. 1 wafer at a processing step  
16 subsequent to that shown by Fig. 8.

17       Fig. 10 is a diagrammatic sectional view of an alternate  
18 embodiment semiconductor wafer fragment at one processing step in  
19 accordance with the invention.

20       Fig. 11 is a view of the Fig. 10 wafer at a processing step  
21 subsequent to that shown by Fig. 10.

22       Fig. 12 is a view of Fig. 11 taken through line 12-12 in Fig. 11.

23       Fig. 13 is a view of the Fig. 10 wafer at a processing step  
24 subsequent to that shown by Fig. 11.

1 Fig. 14 is a view of Fig. 13 taken through line 14-14 in Fig. 13.

2 Fig. 15 is a view of the Fig. 10 wafer at a processing step  
3 subsequent to that shown by Fig. 13.

4 Fig. 16 is a view of Fig. 15 taken through line 16-16 in Fig. 15.

5 Fig. 17 is a diagrammatic sectional view of another alternate  
6 embodiment semiconductor wafer fragment at one processing step in  
7 accordance with the invention, and corresponds in sequence to that of  
8 Fig. 16.

#### 9 10 11 DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

12 This disclosure of the invention is submitted in furtherance of the  
13 constitutional purposes of the U.S. Patent Laws "to promote the  
14 progress of science and useful arts" (Article 1, Section 8).

15 Referring to Fig. 1, a semiconductor wafer in process is indicated  
16 generally with reference numeral 10. Such comprises a bulk  
17 monocrystalline silicon substrate 12. In the context of this document,  
18 the term "semiconductor substrate" is defined to mean any construction  
19 comprising semiconductive material, including, but not limited to, bulk  
20 semiconductive materials such as a semiconductive wafer (either alone  
21 or in assemblies comprising other materials thereon), and semiconductive  
22 material layers (either alone or in assemblies comprising other  
23 materials). The term "substrate" refers to any supporting structure,  
24

1 including, but not limited to, the semiconductor substrates described  
2 above.

3 A gate dielectric layer 14, such as silicon dioxide, is formed over  
4 semiconductor substrate 12. A conductively doped semiconductive  
5 layer 16 is formed over gate dielectric layer 14. Conductively doped  
6 polysilicon is one example. An insulative capping layer 18 is formed  
7 over semiconductive layer 16. An example material is again silicon  
8 dioxide. Intervening conductive layers, such as refractory metal silicides,  
9 might of course also be interposed between layers 16 and 18. An etch  
10 stop layer 20 is formed over insulative capping layer 18. An example  
11 preferred material is polysilicon.

12 Referring to Fig. 2, the above-described layers over substrate 12  
13 are patterned and etched into a plurality of exemplary transistor gate  
14 lines 22, 24 and 26. Lines 22, 24 and 26 have respective opposing  
15 sidewalls 27 and 28, 29 and 30, and 31 and 32. Lines 22, 24 and 26  
16 are shown in the form of field effect transistor gates, although other  
17 conductive lines are contemplated. LDD implant doping is preferably  
18 conducted to provide illustrated implant regions 33 for the transistors.  
19 One example implant dose for regions 33 would be  $2 \times 10^{13}$  ions/cm<sup>2</sup>.  
20 Alternately, the LDD implant doping can be implanted after source/drain  
21 regions have been formed (or a combination of both). Forming LDD  
22 regions later in the process reduces the  $D_t$  seen by such implants.

23 Referring to Fig. 3, an insulating layer 34 is deposited over  
24 substrate 12 and lines 22, 24 and 26. The thickness of layer 34 is



1 preferably chosen to be greater than that of the combined etch stop  
2 layer, capping layer and semiconductor layer, and to be received  
3 between the transistor gate lines to fill the illustrated cross-sectional  
4 area extending between adjacent gate lines. Example and preferred  
5 materials include undoped silicon dioxide deposited by decomposition of  
6 tetraethylorthosilicate, and borophosphosilicate glass.

7 Referring to Fig. 4, insulative material layer 34 has been  
8 planarized. Such is preferably accomplished by chemical-mechanical  
9 polishing using etch stop layer 20 of gates 22, 24 and 26 as an etch  
10 stop for such polishing.

11 Referring to Fig. 5, a layer of photoresist 36 has been deposited  
12 and patterned. Insulative material 34 is etched to effectively form  
13 contact openings 38, 39 and 40 therein to proximate substrate 12, and  
14 preferably effective to outwardly expose material of semiconductor  
15 substrate 12. For purposes of the continuing discussion, the exposed  
16 portions of semiconductor substrate 12 are designated as locations 42,  
17 43 and 44. The depicted etching constitutes but one example of  
18 etching insulating layer 34 proximate lines 22 and 24 along at least a  
19 portion of facing sidewalls 28 and 29. Such portion preferably  
20 comprises a majority of the depicted sidewalls, and as shown constitutes  
21 the entirety of said sidewalls to semiconductor substrate 12.

22 With respect to line 26, the illustrated insulating layer 34 etching  
23 is conducted along at least a portion of each of opposing line  
24 sidewalls 31 and 32. Further with respect to lines 22 and 24, such

1 etching of insulating layer 34 is conducted along portions of sidewalls 28  
2 and 29, and not along the respective opposing sidewalls 27 and 30.  
3 Further, such insulating layer 34 etching exposes conductive material of  
4 at least one of the transistor gates, with such etching in the illustrated  
5 example exposing conductive material 16 of sidewalls 28, 29, 31 and 32  
6 of the illustrated transistor gates. Further with respect to gate lines 22  
7 and 24, the insulative material is etched to remain/be received over the  
8 one sidewalls 27 and 30, and not sidewalls 28 and 29.

9 After etching of layer 34, at least one of the exposed sidewalls  
10 is covered with insulating material. Such preferably comprises deposition  
11 of an insulating layer 46 over substrate 12; lines 22, 24 and 26; and  
12 planarized and etched insulative material 34 to a thickness which less  
13 than completely fills at least some of the contact openings. Such layer  
14 preferably comprises a spacer forming layer, with silicon dioxide and  
15 silicon nitride being but two examples.

16 Referring to Fig. 7, spacer forming layer 46 is anisotropically  
17 etched to form insulative sidewall spacers 47, 48, 49, 50 and 52. Such  
18 constitutes but one example of forming the illustrated insulative sidewall  
19 spacers. In one implementation, insulating layer 34 is received between  
20 at least one of the sidewalls and one of the sidewall spacers, for  
21 example as shown with respect to line 24 between sidewall 30 and  
22 spacer 49. Further with respect to this example line 24, insulative  
23 material 34 is received between the one sidewall 30 and the one  
24 insulative spacer 49 formed thereover, and is not received between the

1 opposing sidewall 29 and the other spacer 48 formed thereover. Yet,  
2 in the depicted section, insulative sidewall spacers 48 and 49, and 50  
3 and 52 are formed over each of the respective opposing line sidewalls  
4 of lines 24 and 26, wherein in the depicted section only one insulative  
5 spacer 47 is formed over one sidewall of line 22. Further, insulative  
6 material 34 received between sidewall 30 and insulative spacer 49 of  
7 line 24 has a maximum lateral thickness which is greater than or equal  
8 (greater as shown) to a maximum lateral thickness of sidewall  
9 spacer 49. Source/drain implanting may occur at this point in the  
10 process, if desired.

11 Referring to Fig. 8, a local interconnect layer 56 is deposited to  
12 overlie at least one of the transistor gates, and ultimately interconnect  
13 locations 42, 43 and 44 of substrate 12, and is thus provided in  
14 electrical connection therewith. An example preferred material for  
15 layer 56 is polysilicon. Due to the spacing constraints between the  
16 insulative spacers of lines 22 and 24 versus that of lines 24 and 26,  
17 layer 56 completely fills contact opening area 38 and less than  
18 completely fills contact opening areas 39 and 40.

19 Depending on the circuitry being fabricated and the desires of the  
20 processor, layer 56 might be *in situ* conductively doped as deposited  
21 and/or separately implanted with conductivity enhancing impurity  
22 subsequent to deposition. Further, any such subsequent implantings  
23 might be masked to only be provided within portions of layer 56 where,  
24 for example, both n-type and p-type substrate regions are being

1 conductively connected by an ultimately conductive interconnect formed  
2 from layer 56. Most preferably, interconnect layer 56 will ultimately  
3 comprise suitably conductively doped semiconductive material. Where  
4 such will comprise both n-type and p-type doping material, another  
5 conductive strapping layer, such as a refractory metal silicide, will ideally  
6 be formed atop layer 56 to avoid or overcome an inherent parasitic  
7 diode that forms where p-type and n-type materials join. Further with  
8 respect to combined n-type and p-type processing, multiple local  
9 interconnect layers might be provided and patterned, and perhaps utilize  
10 intervening insulative layers, spacers or etch stops. Further prior to  
11 deposition of layer 56, a conductive dopant diffusion barrier layer might  
12 also be provided.

13 Example preferred implantings, whether p-type, n-type, or a  
14 combination of the same, is next described still with reference to Fig. 8.  
15 Such depicts two preferred implantings represented by peak implant  
16 locations or depths 58 and 60. Such are preferably accomplished by  
17 two discrete implantings which provide peak implant location 60 deeper  
18 relative to layer 56 than implant 58. For example within layer 56 in  
19 contact openings 38 and 39, regions of layer 56 are shown where peak  
20 implant 60 is deeper within layer 56 than is peak implant 58. Yet, the  
21 peak implant location or depth for implant 60 is preferably not chosen  
22 to be so deep to be within conductively doped material 16 of lines 22,  
23 24 and 26. Further in contact opening locations 39 and 40, the  
24 implanting to produce depicted implant 60 is conducted through local

1 interconnect layer 56 and into semiconductor substrate material 12  
2 therebeneath. Diffusing of the conductivity enhancing impurity provided  
3 within layer 56 might ultimately occur from local interconnect layer 56  
4 into semiconductor substrate material 12 therebeneath within  
5 locations 42, 43 and 44 to provide the majority of the conductivity  
6 enhancing impurity doping for the source/drain regions of the illustrated  
7 transistor lines. Depending on the processor's desire and the degree  
8 of diffusion, such source/drain regions might principally reside within  
9 semiconductor substrate material 12, or reside as elevated source/drain  
10 regions within layer 56.

11 Further and as shown, layer 56 in certain locations acts as a  
12 spacer for the deeper implant. Further, such may actually reduce  
13 junction capacitance by counter doping halo implants that are further  
14 away from gate polysilicon. This can provide flexibility in the settings  
15 of the halo implants.

16 Referring to Fig. 9, local interconnect layer 56 is formed (i.e., by  
17 photopatterning and etching) into a local interconnect line 57 which  
18 overlies at least portions of illustrated conductive lines 24, 26 and 28,  
19 and electrically interconnects substrate material locations 42, 43 and 44.

20 Further considered aspects of the invention are next described  
21 with reference to Figs. 10-16. Fig. 10 illustrates a semiconductor wafer  
22 fragment 10a comprising a bulk monocrystalline silicon substrate 12.  
23 Semiconductor substrate 12 has been patterned to form field isolation  
24 region 64 and active area region 62. In the illustrated example,

1 material 66 of field isolation region 64 comprises silicon dioxide  
2 fabricated by LOCOS processing. Such might constitute other material  
3 and other isolation techniques, for example trench and refill resulting  
4 from etching trenches into substrate 12 and depositing oxide such as by  
5 CVD, including PECVD.

6 Fragment 10a in a preferred and exemplary embodiment comprises  
7 an extension of fragment 10 of the first described embodiment, such as  
8 an extension in Fig. 10 starting from the far right portion of Fig. 4 of  
9 the first described embodiment. Accordingly, insulating layer 34 is  
10 shown as having been deposited and planarized,

11 Referring to Figs. 11 and 12, a trench 68 is etched into field  
12 isolation material 66 and is received within insulating layer 34. Such  
13 includes opposing insulative sidewalls 77 and a base 79. Trench 68 in  
14 this illustrated example extends to an edge 70 of isolation material 66  
15 proximate, and here extending to, active area substrate material 12 of  
16 region 62. An example preferred depth for trench opening 68 is 10%  
17 to 20% greater than the combined thickness of the conductive and  
18 insulating materials of gate stacks 22, 24 and 26.

19 Referring to Figs. 13 and 14, a conductive material 72 is  
20 deposited to at least partially fill trench 68, and electrically connects  
21 with substrate material 12 of active area region 62. As shown,  
22 material 72 is preferably deposited to overfill trench 68. The width of  
23 trench 68 is preferably chosen to be more narrow than double the  
24 thickness of layer of material 72. Such preferred narrow nature of

1 trench 68 facilitates complete filling thereof with conductive material 72  
2 in spite of its depth potentially being greater than the globally  
3 deposited thickness of layer 72.

4 Referring to Figs. 15 and 16, conductive layer 72 has been etched  
5 to produce the illustrated local interconnect line 75 which includes a  
6 line segment 76 received within trench 68 over isolation material 66.  
7 A small degree of overetch preferably occurs as shown to assure  
8 complete removal material 72 from over the outer surface of insulating  
9 layer 34. Ideally, the shape of trench 68 is chosen and utilized to  
10 define the entire outline and shape of the conductive line being formed  
11 relative to isolation material 66. Further, conductive material of line 75  
12 preferably contacts material 66 of trench sidewalls 77 and base 79.

13 Fig. 17 illustrates an exemplary alternate wafer fragment 10b  
14 embodiment corresponding to Fig. 16, but using a trench isolation  
15 oxide 66b as opposed to LOCOS oxide 66. An exemplary preferred  
16 trench filled line 68b is shown.

17 In compliance with the statute, the invention has been described  
18 in language more or less specific as to structural and methodical  
19 features. It is to be understood, however, that the invention is not  
20 limited to the specific features shown and described, since the means  
21 herein disclosed comprise preferred forms of putting the invention into  
22 effect. The invention is, therefore, claimed in any of its forms or  
23 modifications within the proper scope of the appended claims  
24 appropriately interpreted in accordance with the doctrine of equivalents.